

# Work Order ID 75212

**\*75212\***

Page 1

October-19-11 10:30:07 AM

Item ID: D2894-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 2.750 Support  
 Start Date: 19/10/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 30/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 11/10/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2894	E

100	HAAS CNC VERTICAL MACHINING #1	0.00
<b>*100*</b>		
HAAS I	Memo	0.00
HAAS CNC vertical machine #1	Machine as per Folio FA253 Tumble & Deburr	

*mf/rt 12/03/16* (x6)

110	QC1- Inspect dimensions to dimension sheet	0.00
<b>*110*</b>		
QC	Memo	0.00
Quality Control		

*mf/rt 12/03/16* (x6)

120	QC8- Inspect parts - second check	0.00
<b>*120*</b>		
QC	Memo	0.00
Quality Control		

*SL 12/03/19*

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo LG	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/3/21 (6)

12/3/21

ME

12-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

October-19-11 10:30:12 AM

Page 1

Work Order ID: 75212

**\*75212\***

Parent Item: D2894-1

**\*D2894-1\***

Parent Item Name: 2.750 Support

Start Date: 19/10/2011

Required Date: 30/11/2011

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP: B02.11.26Added mask holeKJ

IPP Rev:C ECN 993 07-11-07 DD verified by:EC

IPP D 08.03.19 Re-format EC verified by DD IPP REV:E

11.10.03 ASPER REV:C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK079		Manufactured	No			100	Each	11.0000	0.5	3			

**\*DSK079\***

D2894-1 TURNING DETAIL

\*\*

RT 12.03.13

Location	Loc Qty	Loc Code
MAT	4	
72634	4	X2
MAT060	7	
43976	1	X1
72658	6	X1

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











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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	75212
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b>	D2894-1
<b>Inspection Dwg:</b> D2894		<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.454	0.474		0.462	0.462	.460	.462	.463
AB	3.062	3.082		3.075	3.072	3.071	3.07	3.072
AC	0.053	0.073		0.062	0.062	.063	.063	.063
AD	1.766	1.786		1.776	1.776	1.775	1.775	1.775
AE	0.020	0.040		0.035	0.035	.034	.034	.034
AF	0.260	0.267		0.260	0.261	.260	.260	.260
AG	0.170	0.190		0.181	0.182	.177	.180	.180
AH	0.150	0.170		0.165	0.165	.157	.159	.159
AI	1.990	2.010		1.998	1.998	1.999	1.996	2.004
AJ	0.240	0.260		0.250	0.250	.250	.250	.250
AK	1.880	1.900		1.886	1.886	1.890	1.880	1.885
AL	0.500	0.505		0.5005	0.5005	.501	.501	.501
AM	0.188	0.194		0.1895	0.1895	.190	.190	.190

6  
.463  
3.073  
.063  
1.776  
.034  
.260  
.180  
.159  
2.004  
.250  
1.887  
.501  
.190

Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"

Accept/Reject	.0015	.003	.0015	.003	.0015
---------------	-------	------	-------	------	-------

.0025

<b>Measured by:</b>	<i>[Signature]</i> 12/03/16	<b>Date:</b>	12/03/16
<b>Audited by:</b>	<i>[Signature]</i> 12/03/16	<b>Date:</b>	12/03/19
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	

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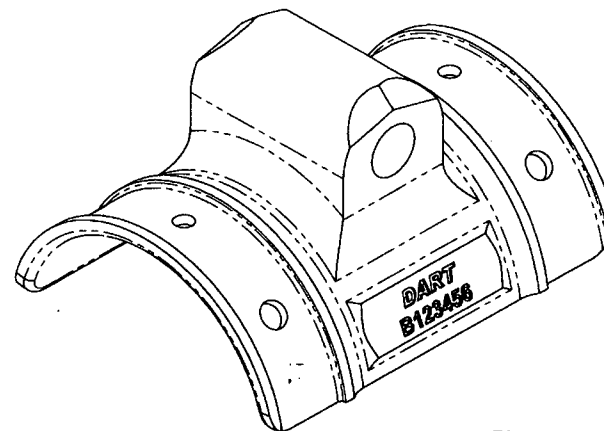
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**NOTE:** Date & initial all entries





**D2894-1 Ø2.750 SUPPORT**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 75212 M.C.J  
11/10/19

**RELEASED**  
2011-09-29  
JNT

**NOTES:**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
PER ASTM A564 OR AMS 5643 OR AISI 630  
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,  
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA  
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE  
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE  
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

E	REMOVE PRIMER & UPDATE MAT'L SPEC (ZN A8-1), 2.00 WAS 2.000 (C3-2), 4.00 WAS 4.000 (C6-2), REF. CAR 11-51	CP	11.09.07
D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM, PER BELL TECH BULLETIN 407-08-84. B5-2 Ø.261 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO. <b>D2894</b>	REV. E
MFG. APPR.		TITLE <b>Ø2.750 SUPPORT</b>	SHEET 1 OF 2
APPROVED		SCALE	NTS
DE APPR.		DATE <b>11.09.07</b>	
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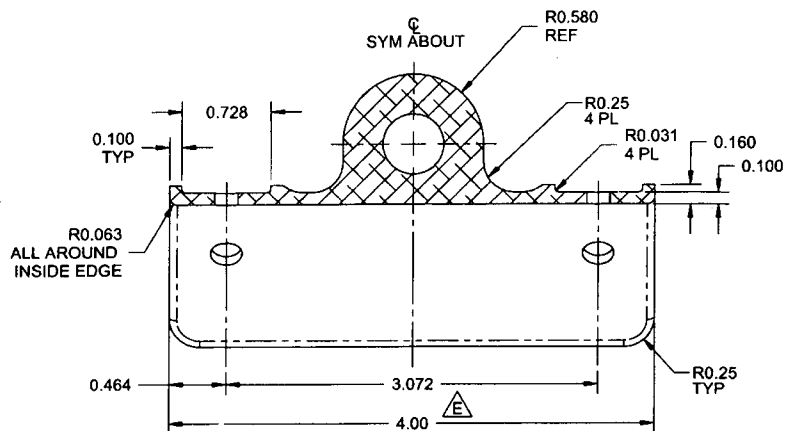
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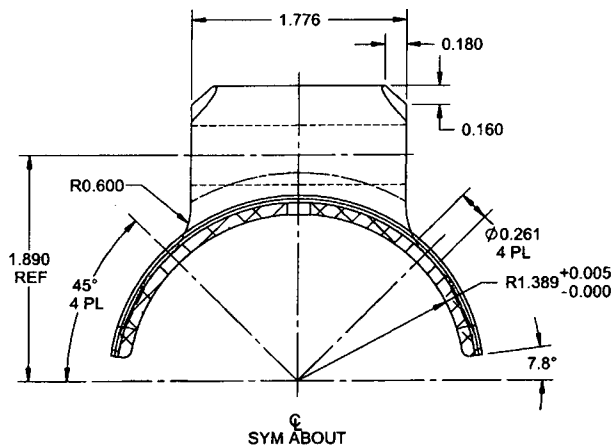
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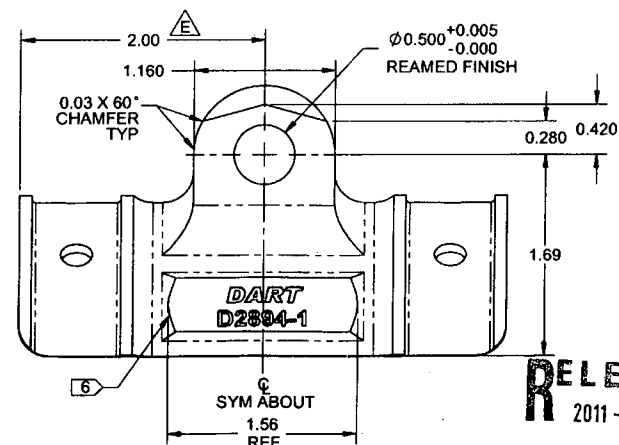
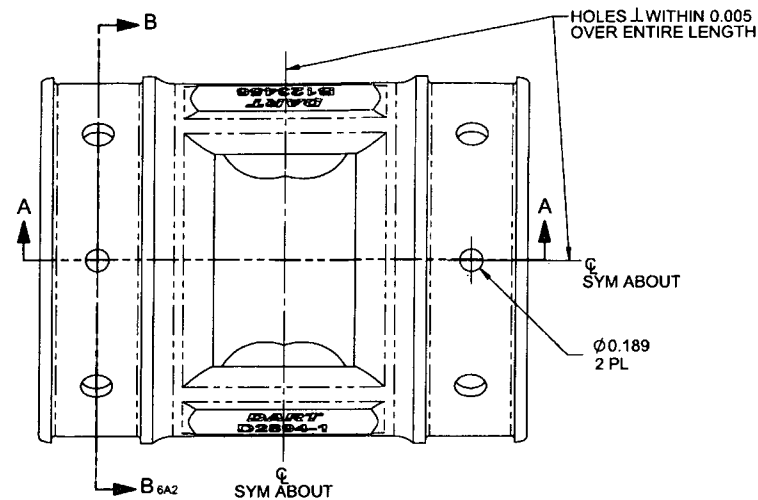
75212



SECTION A-A



SECTION B-B C3-2  
(VIEW ROTATED 90°)



D2894-1 Ø2.750 SUPPORT

RELEASED  
2011-09-29

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. <b>D2894</b>	REV. <b>E</b>
MFG. APPR.	AS	TITLE	SHEET 2 OF 2
APPROVED	AS	<b>Ø2.750 SUPPORT</b>	SCALE
DE APPR.	AS		NTS
DATE	<b>11.09.07</b>	<b>COPYRIGHT © 2002 BY DART AEROSPACE LTD</b>	
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